



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2893-1
Job Sheet 209411



Part No: D2893-1

Job Qty: 12 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/29/20

Job Tracking No:

Due Date: 5/15/20

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG D2893 REV D IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E
Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15
add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C ver:ECDWG /IPP Rev. I 19.10.01 New
issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	5/14/20		2.00	23.53	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	12 pcs	5/14/20		0.00	0.00	QC 8 - 12		<i>20-05-1</i> <i>20/05/23</i>
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S279100



Part: D2893-1

Job No: 209411

Serial No/Batch: S279100

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 05/22/20

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						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
						QC 8 - 73	
						QC 8 - 82	
130	Crosstubes - 2 - B4B	12 pcs	5/15/20	0.00	2.00	Crosstubes - 1 - B4B	
						Crosstubes - 2 - B4B	
						Crosstubes - 3 - B4B	
						Crosstubes - 4 - B4B	
140	QC 3	12 pcs	5/15/20	0.00	0.00	QC 3 - 10	DAS 87 9-89 MAY 28 2020
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	DAS 10 9-89 MAY 29 2020
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	
						QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	12 pcs	5/15/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	DAS 84 9-89 LG 050
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180	QC 21 - SA	12 pcs	5/15/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
					Broussard

DAS
21
9-00

JUN 01 2020

Part Op **100** - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and use DT10660 apply 3M Scotch-Weld as per dwg. \$ 206999
140 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container	
DSK078	D2893-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	S257569	x6

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	6	9	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

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DART AEROSPACE LTD		Work Order: 209411
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 3

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.125	0.160		.148	.148	.147	.146	.148
AB	0.040	0.060		.047	.046	.048	.049	.050
AC	Ø0.260	Ø0.266		.262	.262	.262	.262	.262
AD	Ø0.187	Ø0.193		.189	.189	.189	.189	.189
AE	0.240	0.250		R.25	R.25	R.25	R.25	R.25
AF	1.347	1.407		1.367	1.361	1.367	1.372	1.369
AG	1.200	1.240		1.209	1.209	1.203	1.214	1.210
AH	0.147	0.167		.157	.158	.164	.157	.160
AI	2.985	3.005		2.998	2.998	2.998	2.997	2.998
AJ	0.400	0.500		.47	.47	.468	.470	.470
AK	4.930	4.990		4.956	4.957	4.950	4.955	4.950
AL	0.125	0.160		.14	.14	.140	.136	.140
AM	R0.053	R0.073		R.063	R.063	R.063	R.063	R.063
AN	R0.240	R0.260		R.25	R.25	R.250	R.25	R.25
AO	R0.021	R0.041		R.032	R.032	.032	R.032	R.032
AP	0.150	0.180		.169	.173	.171	.169	.170
AQ	0.053	0.073		R.063	R.063	.063	R.063	R.063
AR	2.302	2.322		2.314	2.316	2.318	2.316	2.318
AS	0.140	0.160		.150	.153	.150	.155	.156
AT	0.040	0.060		.053	.053	.049	.054	.053
Accept/Reject								

Measured by: DE/SBL	Date:
Audited by: MK	Date: 20/05/23
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG	DP

DART AEROSPACE LTD		Work Order: 209 411
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page: 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	10	27	38	49	50
HAAS Section								
AA	0.125	0.160		.145	.140	0.143	0.143	0.143
AB	0.040	0.060		.052	.050	0.050	0.050	0.050
AC	Ø0.260	Ø0.266		.262	.262	0.261	0.261	0.261
AD	Ø0.187	Ø0.193		.189	.189	0.189	0.189	0.189
AE	0.240	0.250		R.25	R.25	R0.250	R0.250	R0.250
AF	1.347	1.407		1.370	1.370	1.370	1.370	1.373
AG	1.200	1.240		1.210	1.211	1.210	1.213	1.211
AH	0.147	0.167		.160	.159	0.160	0.156	0.162
AI	2.985	3.005		2.998	2.997	2.996	2.996	2.996
AJ	0.400	0.500		.468	.472	0.450	0.450	0.450
AK	4.930	4.990		4.957	4.955	4.955	4.955	4.955
AL	0.125	0.160		.140	.140	0.140	0.140	0.140
AM	R0.053	R0.073		R.063	R.063	R0.063	R0.063	R0.063
AN	R0.240	R0.260		R.250	R.250	R0.250	R0.250	R0.250
AO	R0.021	R0.041		R.032	R.032	R0.032	R0.032	R0.032
AP	0.150	0.180		.168	.167	0.169	0.173	0.172
AQ	0.053	0.073		R.063	R.063	R0.063	R0.063	R0.063
AR	2.302	2.322		2.320	2.328	2.316	2.315	2.313
AS	0.140	0.160		.150	.154	0.144	0.147	0.149
AT	0.040	0.060		.049	.050	0.053	0.052	0.048
Accept/Reject								

Measured by: SBL/A.E. **Date:** 20-05-21

Audited by: [Signature] **Date:** 20/05/23

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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DART AEROSPACE LTD		Work Order: 209 411
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page: 3 of 3

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.125	0.160		0.143	0.143			
AB	0.040	0.060		0.050	0.050			
AC	Ø0.260	Ø0.266		Ø0.261	Ø0.261			
AD	Ø0.187	Ø0.193		Ø0.189	Ø0.189			
AE	0.240	0.250		R0.250	R0.250			
AF	1.347	1.407		1.372	1.374			
AG	1.200	1.240		1.213	1.211			
AH	0.147	0.167		0.160	0.163			
AI	2.985	3.005		2.998	2.996			
AJ	0.400	0.500		0.450	0.450			
AK	4.930	4.990		4.956	4.956			
AL	0.125	0.160		0.140	0.140			
AM	R0.053	R0.073		R0.063	R0.063			
AN	R0.240	R0.260		R0.250	R0.250			
AO	R0.021	R0.041		R0.032	R0.032			
AP	0.150	0.180		0.172	0.172			
AQ	0.053	0.073		R0.063	R0.063			
AR	2.302	2.322		2.319	2.319			
AS	0.140	0.160		0.157	0.151			
AT	0.040	0.060		0.051	0.047			
Accept/Reject								

Measured by: B.A.	Date: 20-05-22
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Audited by: J.M.	Date: 20/05/23
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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